

ESAB 98

ESAB 98 is a Cr-Ni-Mo alloyed hydrogen controlled iron powder type electrode, for welding high tensile strength steels. The electrode deposits, tough and crack resistant welds. The optimum addition of iron powder permits the use of higher currents and results in improved arc characteristics coupled with higher metal recovery. The operational characteristics are excellent in all positions. ESAB 98 finds extensive use in pressure vessels, piping, penstock, earth moving equipment, machinery parts, automobile parts, chemical plants etc.

Specifications

Classifications	SFA/AWS A5.5 : E9018M
Welding Current	AC, DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Cr-Ni-Mo alloyed
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	570 MPa	640 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-50 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	1.00	0.40	1.60	0.10	0.25

Deposition Data

Diameter	Current
2.5 x 350.0 mm	50-90 A
3.15 x 450.0 mm	90-140 A
4.0 x 450.0 mm	140-190 A
5.0 x 450.0 mm	190-240 A